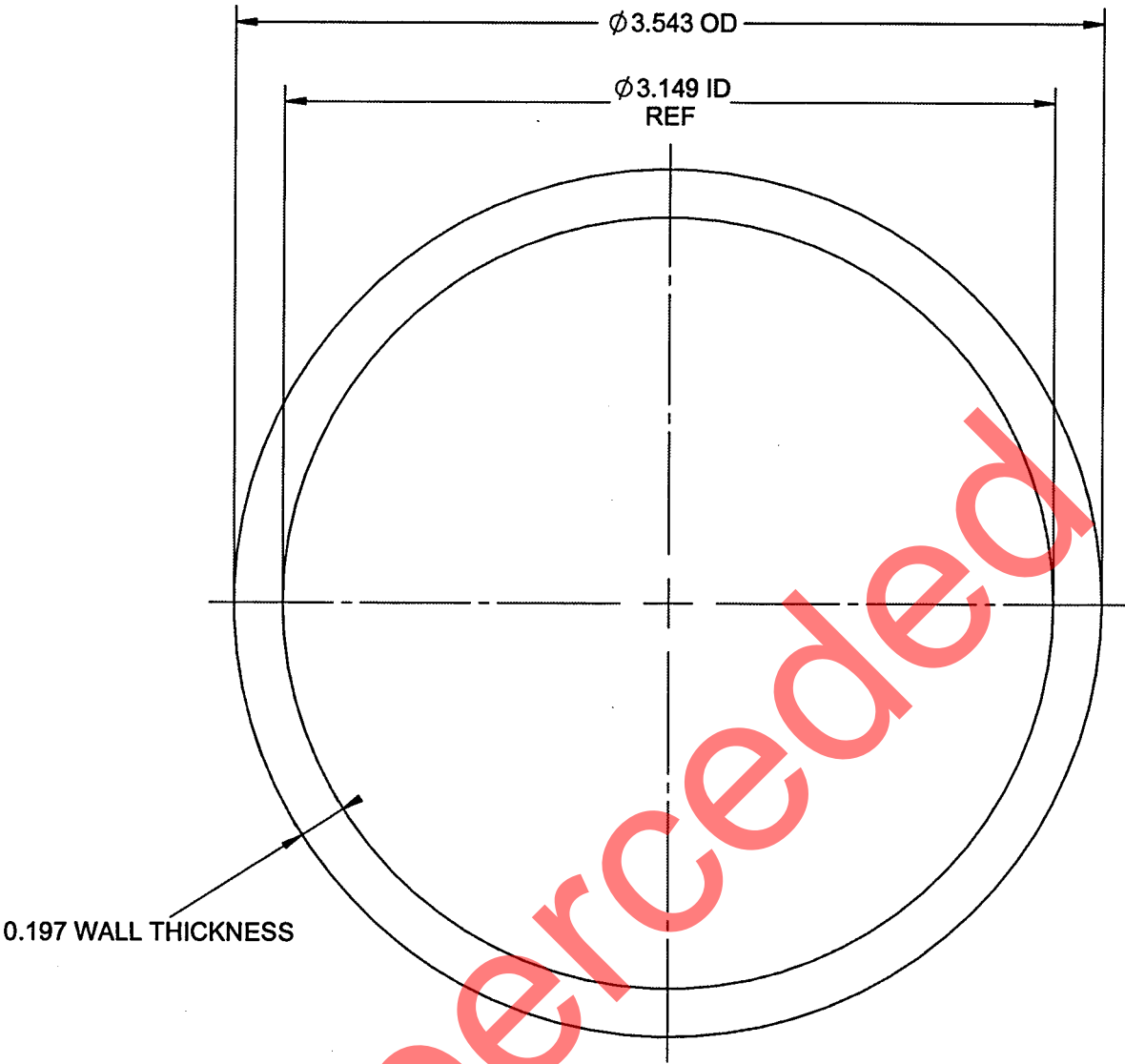


SPECIFICATION CONTROL DRAWING



D6027-XXX CROSSTUBE MATERIAL

WHERE XXX IS LENGTH IN INCHES
EG. 103" LONG TUBE: D6027-103

NOTES:

- 1) MATERIAL: 3.543 OD X 0.197 WALL 7075-T73/T73510/T73511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11 OR ASTM B210 OR ASTM B241) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 68 KSI
MINIMUM YIELD TENSILE STRENGTH = 58 KSI
- 2) FINISH: NONE
- 3) TOLERANCES: PER ANSI H35.2 AS FOLLOWS:
O.D.: +/- 0.015 MEAN (+/- 0.030 INCLUDING OVALITY)
WALL: +/- 0.013 MEAN (+/- 0.020 INCLUDING ECCENTRICITY)
LENGTH: XXX +0.500/-0.000
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.
THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 AS SOON AS POSSIBLE ONCE MATERIAL IS RECEIVED FROM SUPPLIER. CHEMICAL CONVERSION COAT MUST BE CARRIED OUT BEFORE SENDING THE EXTRUSION TO AN OUTSIDE VENDOR.

RELEASED
2017-02-10
ECN 17-510

APPROVED

B	ADDED NOTE 9	ML	17.01.20
A	NEW ISSUE	ML	16.03.24
REV.	DESCRIPTION		BY DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	JMH	DRAWING NO. D6027	REV. B SHEET 1 OF 1
MFG. APPR.	LL		
APPROVED	WM	TITLE	SCALE
DE APPR.	DSS	CROSSTUBE MATERIAL	NTS
DATE	17.01.20	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	